

Date: Thursday, 18/09/2008 11:41:19 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WINDOW
Job Number :	42120		
Estimate Number :	11176		
P.O. Number :		Part Number :	D32903
This Issue :	18/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3290 REV C
First Issue :	1/1	Project Number :	N/A
Previous Run :	39873	Drawing Revision :	C
	Type :	Material :	
	THERMOFORMING	Due Date :	25/09/2008
Written By :		Qty:	12
Checked & Approved By :		Um:	Each
Comment :	Est. A 04.08.18 New issue KJ/RF Est. B 06.05.09 Ecn 798 EC Est. C 07.05.29 Thermoform in-house DL Est. D 07.09.28 rev C dwg EC verified by: DD Est. E 07.11.28 Add --Hand finish deburring DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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m 109137



Comment: Qty.: 3.1500 sf(s)/Unit Total: 37.8000 sf(s)

Polycast II or plexiglass G.125"

~~108762~~ 1B 8-9-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3290

Dwg Rev: E

Prog Rev: E

1B 8-9-18

(B)

2-Deburr if necessary

→ SMO 08/09/29

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-9-18



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/04/18 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-3 PAR #: N/A Fault Category: Prod / ~~Prod~~ not small NCR: Yes No DQA: D Date: 08/10/16

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42120</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/10/16</u>	<u>20</u>	<u>two windows found with cutouts from water jet.</u>	<u>[Signature]</u> <u>10/10/12</u>	<u>Build out piece to Thermolamin</u>	<u>[Signature]</u> <u>08/10/08</u>	<u>[Signature]</u> <u>08/10/08</u>	<u>[Signature]</u> <u>10/10/12</u>	<u>[Signature]</u> <u>08/10/12</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 42120

Part Number: D32903

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Without removing protective skin
remove sharp edge by degurring.

BB 08/10/07 X 13

6.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. C

Folio Rev. B

*See Pb on Previous Page

2-Engrave part# & batch#,
(D3290-3)

BB 08/10/08 X 13

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances

BB 08/10/08 X 13

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/10/08

9.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

BB 08/10/08 X 13

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/08

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP 42121

08/10/08 X 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



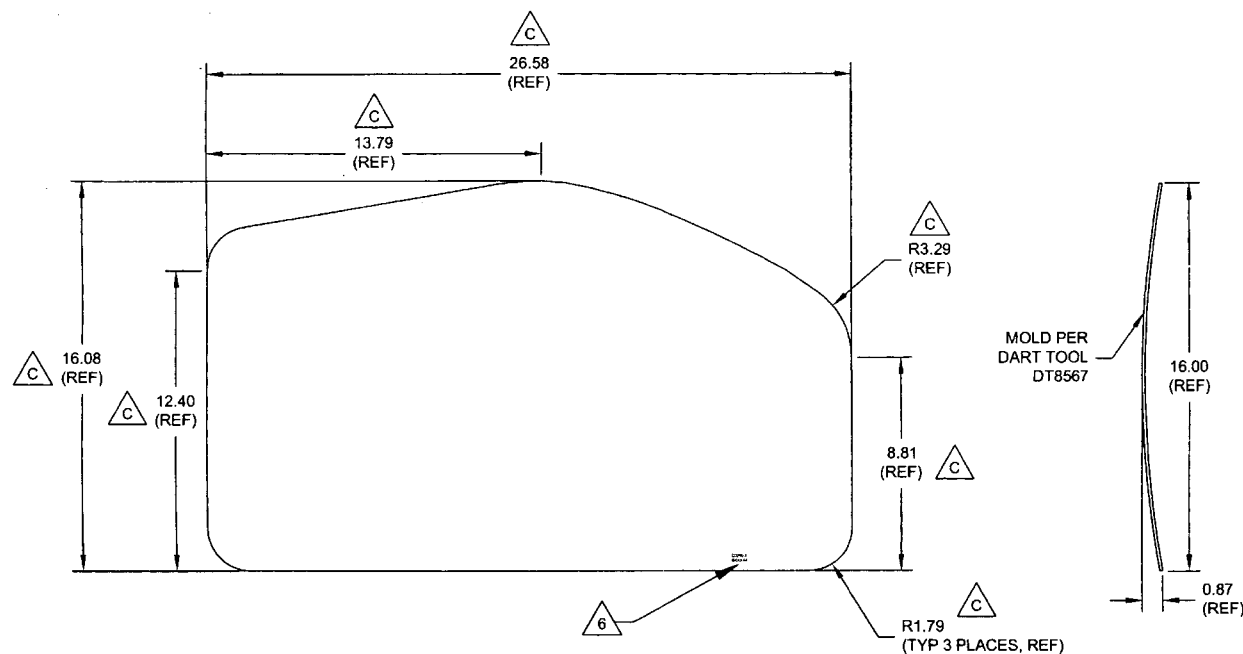
08/10/15 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-15



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

RELEASED
07.07.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART AEROSPACE LTD	Work Order: 42120
Description: WINDOW	Part Number: D32903
Inspection Dwg: D3290-3, Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x


First Article

x

Prototype

[illegible]

Measured by:	B
Date:	8-9-18

Audited by:	
Date:	08/09/18

Prototype Approval:	1
Date:	4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	